

Work Order ID 73637-2 *split*



Page 1

Thursday, September 08, 2011 8:57:53 AM

Item ID: D3916-5

Accept



Setup Start



Revision ID:

Item Name: Light Rib

Stop



Start Date: 9/8/2011 Start Qty: 9.00

Required Date: 9/13/2011 Req'd Qty: 9.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *U*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9566

*** Make line at 9.00" annd use jig for other line***

3- Trim access tube material to finish size as per dwg D3916

SAD 11-09-27

110

QC6- Inspct dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

QC 11-09-29

120

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

QC 11-09-29

Work Order ID 73637

Thursday, September 08, 2011 8:57:53 AM



Page 2

Item ID: D3916-5

Accept

Revision ID:

Item Name: Light Rib

Start Date: 9/8/2011 Start Qty: 9.00

Required Date: 9/13/2011 Req'd Qty: 9.00

Reference:

Approvals: Process Plan: Date: Tooling:

QC: Date: SPC (Y/N):

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

I30

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11/10/34
MK
1109-29

Picklist Print

Thursday, September 08, 2011 8:57:50 AM

Page 1

Work Order ID: 73637



Parent Item: D3916-5



Parent Item Name: Light Rib

Start Date: 9/8/2011

Required Date: 9/13/2011

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

979.9268

4.166

39.46737



SAD

11-69-27

Square Tubing

Location

Loc Qty

Loc Code

MAT034

979.9268158

116610

0.8383

117721

0.3234

117999

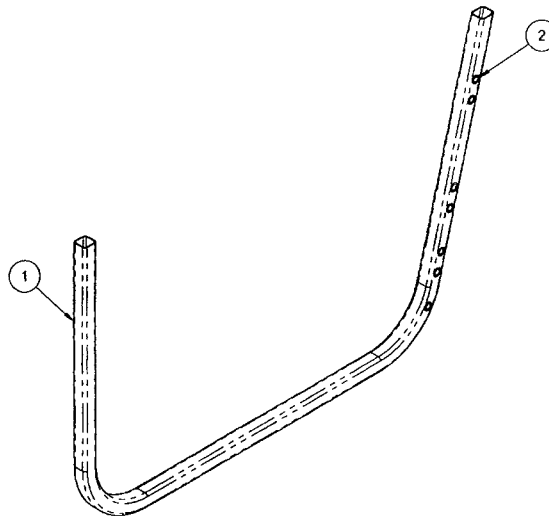
394.765116

118460

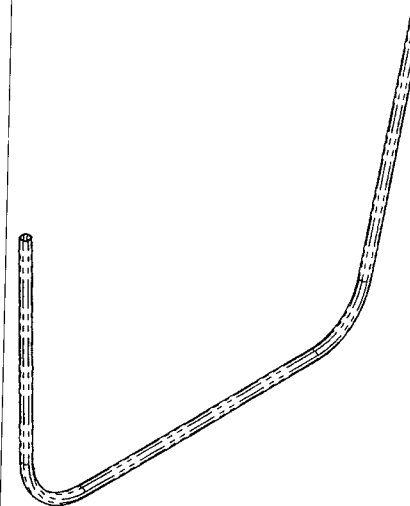
584

35.3019

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



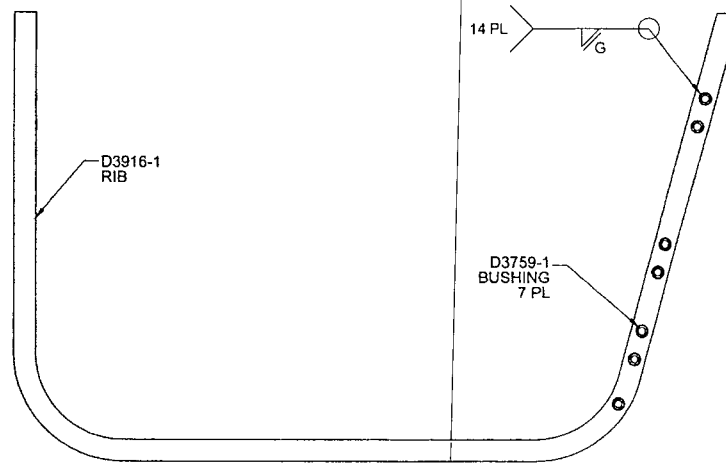
D3916-5 LIGHT RIB

OK 10.12.21
~~UNDER REVIEW~~
 ADDITION OF HOLE + BUSHING
 ON D3916-041-1 RIBS.

RELEASED
 2010-03-12
 JWP

v/o
 73637

A		NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS			DART AEROSPACE LTD	
DRAWN	JPH			HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH			DRAWING NO.	REV. A
MFG. APPR.	JPH			D3916	SHEET 1 OF 4
APPROVED	JPH			TITLE	SCALE
DE APPR.	JPH			RIB ASSY, 350 BASKET	NTS
DATE	10.03.04			<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY REPAIRS OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITH OUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3916-041 RIB ASSY

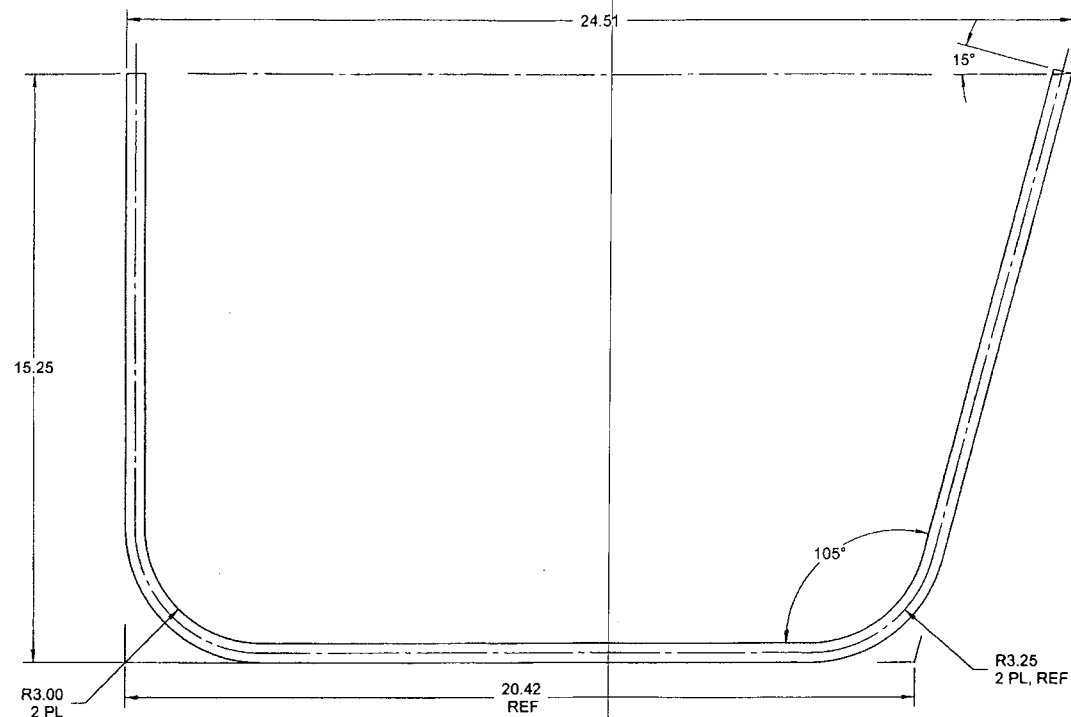
RELEASED
2010-03-12
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

73637

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D3916	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	RIB ASSY, 350 BASKET	NTS
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9 D3916-5 LIGHT RIB

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

73637

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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